

October-05-12 9:15:53 AM

Page 1

**Accept**

**Setup Start**

**\*NS1\***

**Stop**

**\*NS2\***

**Start Date:** 10/05/12      **Start Qty:** 15.00

**\*15\***

**Cust Item ID:**

**Required Date:** 10/31/12      **Req'd Qty:** 15.00

**\*15\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:** *ML5*

Date: 12-10-05

**Tooling:**

**Date:**

Run Start

**\*NR1\***

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

**Stop**

**\*NR2\***

## Waterjet

**FEOW CNC Waterjet**

2074.063

## Memo

1-Cut as per Dwg.

Dwg Rev: *N/C*

Prog Rev: N/C

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

\*120\*

QC

## Quality Control

## Memo

**Work Order ID 91274**

October-05-12 9:15:53 AM

**\*91274\***

Page 2

Item ID: 647.4716

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacer

Start Date: 10/05/12 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

**\*140\***

Outsource4

Memo

0.00

Outsource process - Anodize

HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

3mb  
12/10/15

15

2/10.18/53

CZ 12/10/17 (15)

4/4/17 (15)

**\*91274\***

October-05-12 9:15:53 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/05/12      **Start Qty:** 15.00      **\*15\***

**Cust Item ID:**

**Required Date:** 10/31/12      **Req'd Qty:** 15.00      **\*15\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Memo

0.00

### Quality Control

170

0.00

**\*170\***

## SprayPaint

## Memo

0,00

### Spray Painting

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 122543

180

### QC14- Inspect Spray Paint

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

# Work Order ID 91274

\*91274\*

Page 4

October-05-12 9:15:53 AM

Item ID: 647.4716 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Spacer  
 Start Date: 10/05/12 Start Qty: 15.00 \*15\* Cust Item ID:  
 Required Date: 10/31/12 Req'd Qty: 15.00 \*15\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 439	0.00							
*190*									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
*200*									
QC	Memo	0.00							
Quality Control									

4/2/14/20 (15)

12/11/22

ME

12-11-21

# Picklist Print

October-05-12 9:15:52 AM

Page 1

Work Order ID: 91274

Parent Item: 647.4716

Parent Item Name: Spacer

Start Date: 10/05/12

Required Date: 10/31/12

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

2024-T3 .063 sheet

Purchased

No

110

sf

122.4200

0.068

10736842

1.1

Jan 12-10-14

Location

Loc Qty

Loc Code

MAT022

122.42

119916

10.1

121197

16.32

123096

96

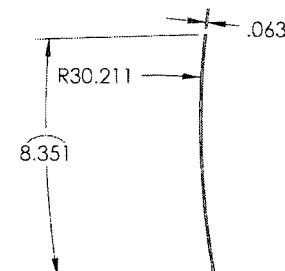
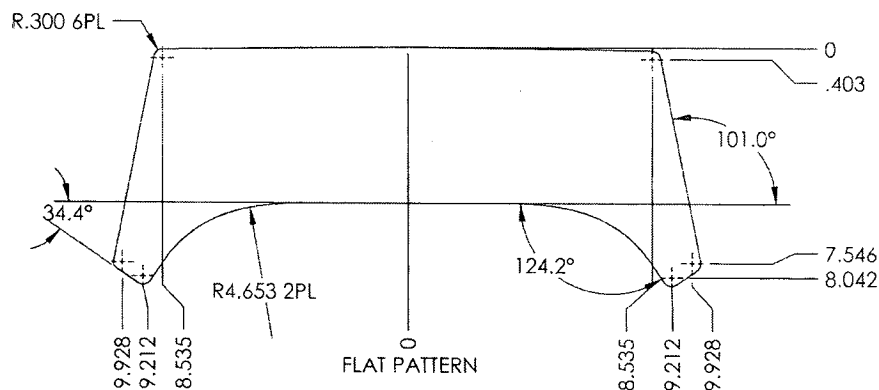
123096

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# NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;  
CARDINAL 4860-50 PRETREATMENT PRIMER  
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST REVISION (REVISED BY)		NYC
2	DATE RELEASE	10-13-07	P. BEAZZO



647.4711

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

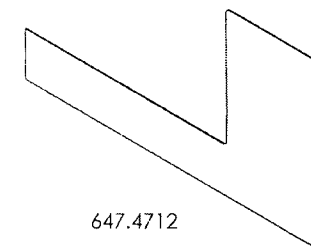
NO. 91224 MLCJ  
12-10-05

QTY	PART #	DESCRIPTION	MATL	SPEC.
1	647.4719	CLIP FWD	△	△
1	647.4718	CLIP AFT RH	△	△
1	647.4717	CLIP AFT LH	△	△
1	647.4716	SPACER	△	△
1	647.4715	CLIP RH	△	△
1	647.4714	CLIP LH	△	△
1	647.4713	BRACKET	△	△
1	647.4712	DOUBLER	△	△
1	647.4711	DOUBLER	△	△
NEXT ASSY (S)		PARTS LIST		
647.2600		APICAL INDUSTRIES		
		2608 TEMPLE HEIGHTS DR.		
		OCEANSIDE, CA. 92056-3512 (760) 724-5300		
		SHEETMETAL		
		SCALE	NOTE	SHEET 1 OF 7

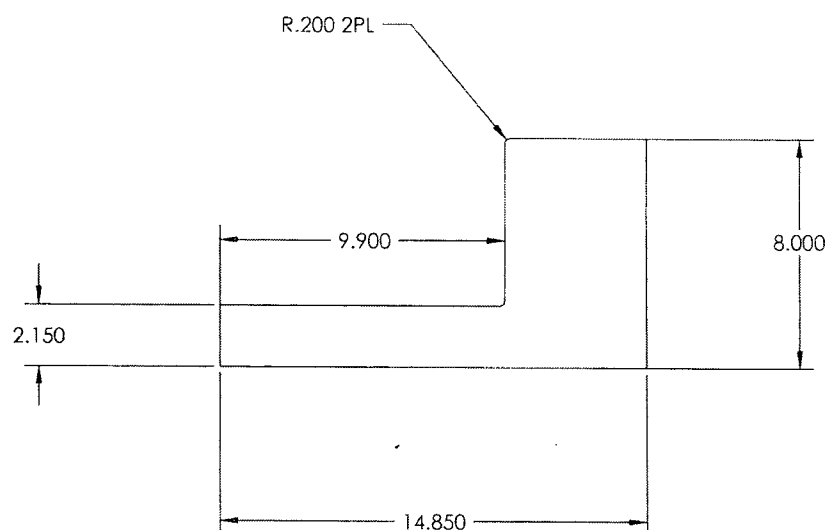
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

91274



647.4712



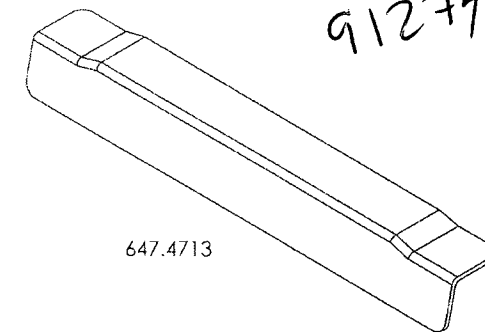
ORIGINAL DATE 06/01/00		REVISED DATE 06/01/00	
DESIGNED BY A. CHAM		CHECKED BY D. MARLER	
DRAWING APPROVAL E. BRADY		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV 8	CODE 07M16
SCALE NONE		DWG. NO. 647.4700	REV. N/C
SHEETMETAL		SHEET 2 OF 2	

APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760)724-5300

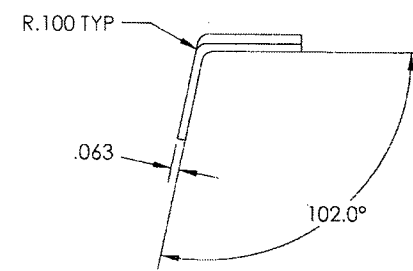
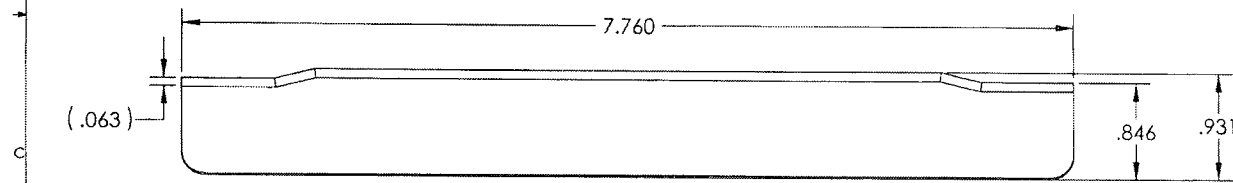
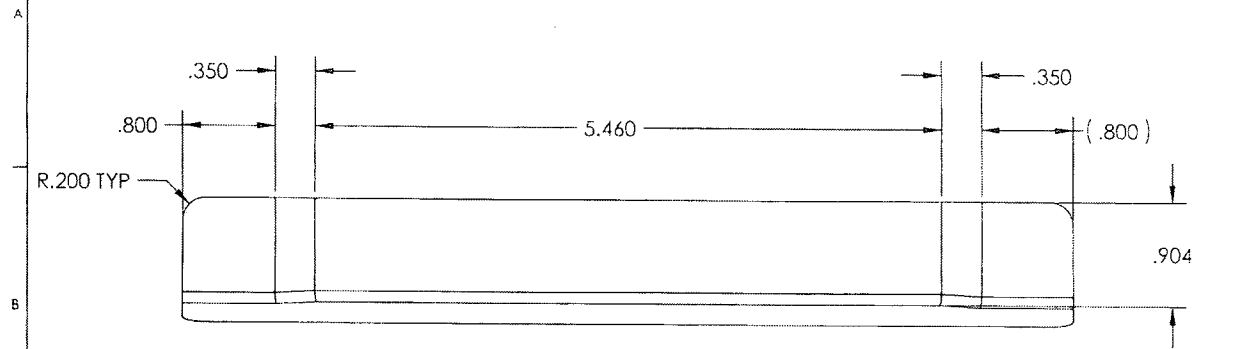
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REV	DATE	APPROVED

91274



647.4713

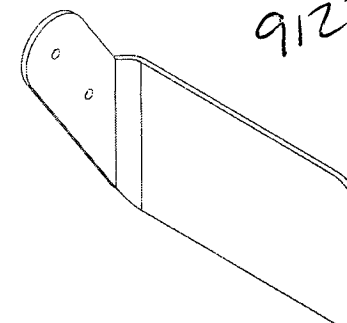
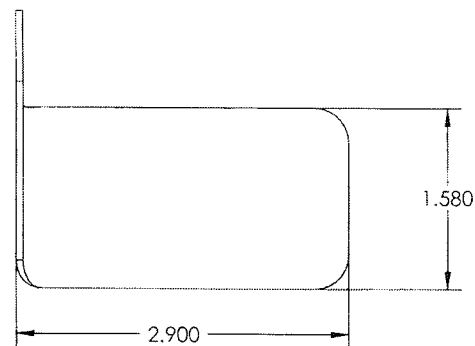
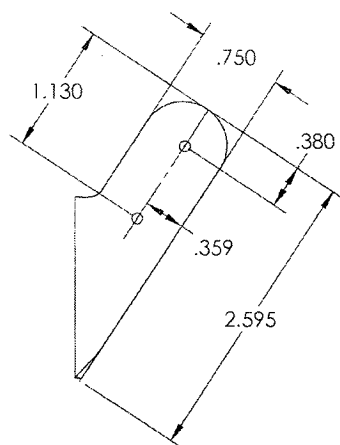


OPERATOR DATE CHECKED BY A. CHART DRAWING APPROVAL CONTRACT NO.	<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300  <b>SHEETMETAL</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.005 4 PLACE DECIMALS ±.0005 5 PLACE DECIMALS ±.00025	REV. 8 CAGE CODE 07MZA DWTG. NO. 647.4700 SCALE NONE SHEET 3 OF 7

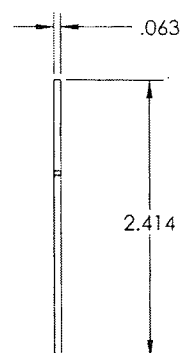
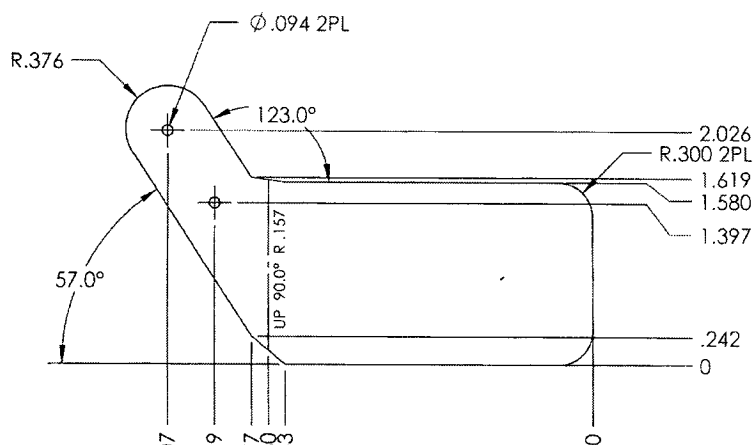


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REV	DESCRIPTION	DATE	APPROVED



647.4714 SHOWN  
647.4715 OPPOSITE



647.4714 FLAT PATTERN SHOWN  
647.4715 BEND DOWN

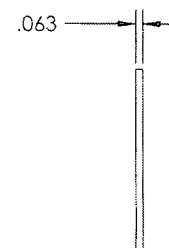
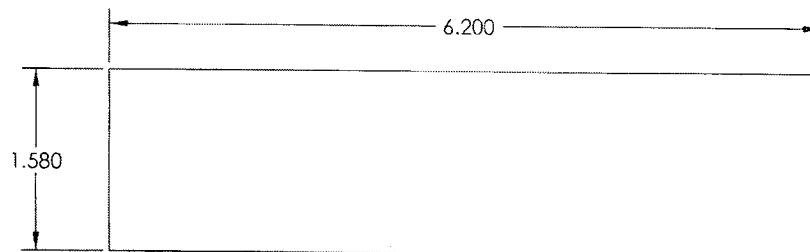
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	SHEETMETAL
DATE: 07/26/06 DWG. NO: 647.4700 SCALE: NONE	REV: N/C SHEET: 4 OF 7

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

91234

647.4716

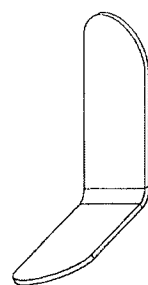
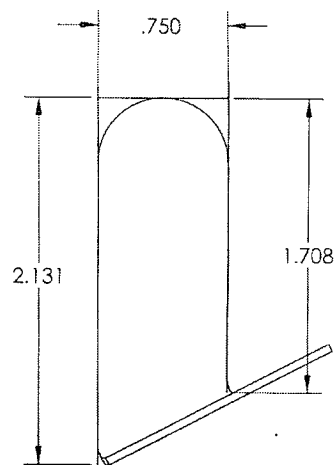


ORIGINAL DATE 10/12/00	APICAL INDUSTRIES		
DESIGNED BY: ENGINEER	2608 TEMPLE HEIGHTS DR.		
A QUANT: 10 SAME	OCEANSIDE, CA. 92056-3512 (760) 724-5300		
APPROVAL: BY: [Signature] DATE: 11/10	SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 ANGLES ±.5°	SHEET: 07/06/00	DATE: 11/10	REV: N/C
	SCALE: NONE		SHEET: 6 OF 7

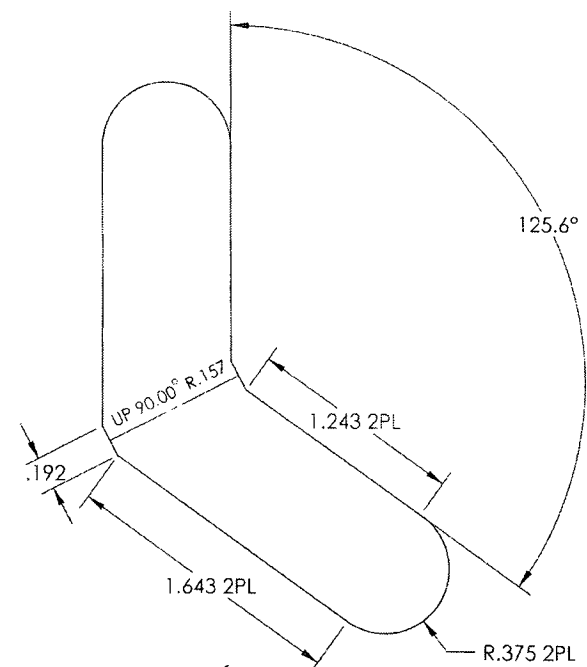
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REV	DESCRIPTION	DATE	APPROVED

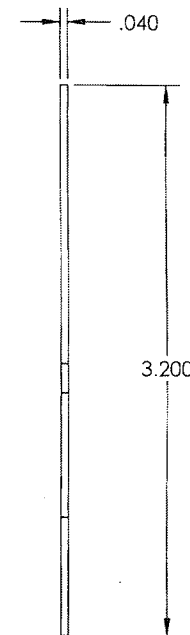
91274



647.4719



647.4719 FLAT PATTERN



ORIGINAL DATE 10/01/01	10/01/01	APICAL INDUSTRIES	
DESIGNED BY A. QUINN	CHECKED BY D. BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY A. QUINN	CHECKED BY D. BARKER	SHEETMETAL	
DESIGNED BY A. QUINN	CHECKED BY D. BARKER	SIZE 8	QTY 647.4700
DESIGNED BY A. QUINN	CHECKED BY D. BARKER	SCALE NONE	REV N/A
DESIGNED BY A. QUINN	CHECKED BY D. BARKER	SHEET 7 OF 7	





A.T.G. Industries Inc.  
 731, rue Industrielle Rd.  
 PLATING DÉPARTEMENT  
 Rockland, On K4K 1T2  
 Canada  
 Ph: (613) 446-4544  
 Fax: (613) 446-4556

## Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ship To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	PO: PO18153 Line:
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	PO: PO18304 Line:
Certificate of Conformance			



A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ship To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE: <u>5/12/12</u>	
	CERTIFIED SIGNATURE: <u><i>mw</i></u>	
	RECEIVER SIGNATURE: _____	